

Monday, December 06, 2010 10:21:56 AM

Page 1

**Accept**

Revision ID:

**Item Name:** Lower Doubler

**Start Date:** 12/6/2010      **Start Qty:** 4.00

**Required Date:** 12/13/2010      **Req'd Qty:** 4.00

**Cust Item ID:**

**Customer:**

**Reference:**

Approvals: Process Plan: MF Date: 10-12-06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

**Draw Nbr**

Revision Nbr

D3608

C

100

0.00

**Abstract**

## FLOW WATER JET

## Waterjet

## Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608

304. 040

Dwg Rev:

Prog Rev: \_\_\_\_\_

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**Abstract**

QC

## Memo

0.00

## Quality Control

120

QC8- Inspect parts - second check

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64455**

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Item ID: D3608-1

Accept

Revision ID:

Item Name: Lower Doubler

Start Date: 12/6/2010 Start Qty: 4.00

Required Date: 12/13/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: 175

0.00



Packaging

Memo

0.00

Packaging

10/12/8 5 (40)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/09  
ME  
10-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, December 06, 2010 10:22:01 AM

Page 1

Work Order ID: 64455



Parent Item: D3608-1



Parent Item Name: Lower Double



Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-03-26 JLM  
 IPP Rev:B 08-10-15 preliminary issue DD verified by:EC  
 IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP  
 Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E  
 10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as  
 per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	60.1900	0.7392	3.112421			
304/316 .040 Sheet												12-10-12-8	

## Location

## Loc Qty

## Loc Code

MAT 56.6  
 115762 10.2  
 115953 46.4  
 MAT20 3.59  
 113062 1.398  
 115440 2.192

115953

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 64455
Description: LOWER Doublor		Part Number: D3608-1
Inspection Dwg: D3608-1 Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

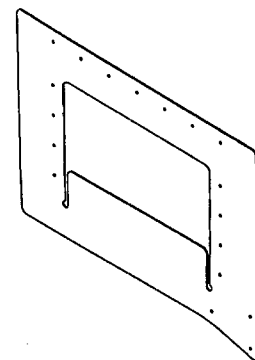
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	±.004 - .001	.100	X		✓ HB02	
1.82	±.030	1.805	X		✓	
.50	±.030	.502	X		✓	
11.63	±.030	11.621	X		✓ PRO HB02	
8.100	±.010	8.099	X		✓ PRO HB02	
1.350	±.010	1.349	X		✓	
2.26	±.030	2.263	X		✓	
1.81	±.030	1.816	X		✓	
3.750	±.010	3.749	X		✓	
1.250	±.010	1.249	X		✓	
8.90	±.030	8.888	X		✓ PRO HB02	
.400	±.010	.401	X		✓	
1.350	±.010	1.348	X		✓	
.345 .345	±.010	.341	X		✓	
1.875	±.010	1.878	X		✓	
.423	±.010	.421	X		✓	
6.98	±.030	6.985	X		✓	
6.73	±.030	6.731	X		✓	
2.90	±.030	2.906	X		✓	
2.15	±.030	2.160	X		✓	
8.44	±.030	8.430	X		✓ PRO HB02	
2.28	±.030	2.248	X		✓	
1.38	±.030	1.373	X		✓	
.040 ±.010		.037	X		✓	

Measured by: RB
Date: 10-12-8








Audited by: S
Date: 10/12/08

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



#64455

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE		10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 IN/INCH D3608-11-3F DELETED BENDING DETAILS. REASON: D3608-11-3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3608	SHEET 1 OF
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NT.
DATE	10.11.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS APPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	